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DISPLAY SUBSTRATE ACCOMMODATING TRAY AND APPARATUS AND METHOD FOR REMOVING THE DISPLAY SUBSTRATE

BACKGROUND OF THE INVENTION

1. FIELD OF THE INVENTION:

The present invention relates to a display substrate accommodating tray used for transporting a display substrate such as, for example, a glass substrate used for producing a display panel for a liquid crystal display device or the like; and an apparatus and method for removing the display substrate from such a display substrate accommodating tray.

2. DESCRIPTION OF THE RELATED ART:

A display panel for a liquid crystal display device usually includes a pair of glass substrates opposed to each other and sealed together, and a liquid crystal material sealed between the pair of glass substrates. In order to produce such a display panel, glass substrates are transported to a display panel production plant. For transporting the glass substrates, a glass substrate accommodating box for accommodating a plurality of glass substrates is usually used. Glass substrates are used in display panels of various types of display devices as well as liquid crystal display devices. The above-mentioned type of glass substrate accommodating box

is also used for transporting glass substrates used for the various types of display devices other than liquid crystal display devices.

The same type of glass substrate accommodating box is used for transporting glass substrates with electrodes and the like formed thereon as half-finished products.

Recently, glass substrates having a thickness of 0.7 mm or less are widely used for various types of display panels. The planar area of the glass substrates which are carried to the display panel production plants is increasing, and even glass substrates having a side length of 1.3 m or greater are used.

Such a large and thin glass substrate is easily warped. When a plurality of such glass substrates are accommodated in the box, the glass substrates may be warped and contact each other, and break during transportation. In order to avoid this, it is necessary to keep an appropriate distance between the glass substrates in the box.

For example, a glass substrate having a thickness

of 0.7 mm and a side length of 1.3 m or greater, when supported along the periphery thereof with a support having a width of 20 to 30 mm, may be warped by 90 mm or greater at the center thereof. In a glass substrate accommodating box, it is necessary to keep a distance of 100 mm or greater between the glass substrates in the box.

A glass substrate is usually removed from a glass substrate accommodating box using a glass substrate adsorption hand. The glass substrate adsorption hand has a pair of flat adsorption pads. Each adsorption pad needs to be inserted between two adjacent glass substrates, which requires a space for inserting the adsorption pad. A flat adsorption pad usually has a thickness of about 20 mm. Therefore, the distance between the glass substrates in the box needs to be the sum of a distance sufficient for preventing the glass substrates from contacting each other even when the glass substrates are warped and a distance of about 20 mm for inserting the adsorption pad.

Due to the necessary space between two adjacent glass substrates, the number of glass substrates which can be accommodated in a glass substrate accommodating box having a prescribed size is limited. This lowers the

space efficiency for transportation and storage, i.e., the number of glass substrates which can be accommodated per unit volume.

The space efficiency can be increased to some extent by increasing the size of glass substrate accommodating boxes so that a greater number of glass substrates can be accommodated in each box and thus a smaller number of boxes are required for accommodating the same number of glass substrates. However, a glass substrate having a side length of 1.3 m or greater is as heavy as about 5 kg. A glass substrate accommodating box accommodating a large number of (for example, 20) glass substrates may not be able to be carried by one worker.

In order to solve these problems, Japanese Laid-Open Publication No. 10-287382 discloses a substrate tray cassette for accommodating one glass substrate. The substrate tray cassette has a bottom section having a lattice structure. The substrate tray cassette is structured such that a plurality of substrate tray cassettes can be stacked vertically. Such a substrate tray cassette allows a large and thin glass substrate to be accommodated without being warped and thus without being

broken during transportation. Since a greater number of substrate tray cassettes can be stacked vertically for transportation and storage, the space efficiency can be improved.

However, this substrate tray cassette has the following problems. The accommodated glass substrate is supported by resin pins, and a pair of adsorption pads of a glass substrate adsorption hand are put into the space below the glass substrate. Such a space for the adsorption pads increases the size of the substrate tray cassette. In addition, the lattice structure of the substrate tray cassette presents a problem in terms of the rigidity thereof, and thus the number of substrate tray cassettes which can be stacked vertically is limited.

SUMMARY OF THE INVENTION

According to one aspect of the invention, a display substrate accommodating tray includes a bottom section for mounting a display substrate thereon in a substantially horizontal fashion; and a frame for surrounding at least a part of the display substrate when the display substrate is mounted on the bottom section. A plurality of openings

are formed in the bottom section through which a plurality of supporting members are to be inserted for, when the display substrate is mounted on the bottom section, raising the mounted display substrate above the bottom section.

In one embodiment of the invention, the frame is provided along a periphery of the bottom section and projects to a level higher than a level of a top surface of the bottom section.

In one embodiment of the invention, the frame has a positioning portion for determining the positional relationship between the display substrate accommodating tray and another display substrate accommodating tray which is to be stacked thereon.

In one embodiment of the invention, the display substrate accommodating tray further includes an engaging section engageable with a carrying member for carrying the display substrate accommodating tray having a display substrate mounted thereon.

In one embodiment of the invention, the bottom section and the frame are integrally formed from a synthetic

resin foam material.

According to another aspect of the invention, an apparatus for removing a display substrate from a display substrate accommodating tray is provided. The display substrate accommodating tray includes a bottom section for mounting a display substrate thereon in a substantially horizontal fashion, with a plurality of openings being formed in the bottom section, and a frame for surrounding at least a part of the display substrate when the display substrate is mounted on the bottom section. The apparatus includes a plurality of first supporting members for, when the display substrate is mounted on the bottom section, raising the mounted display substrate above the bottom section; and a second supporting member for supporting the display substrate accommodating tray. The plurality of first supporting members raise the mounted display substrate by moving upward relative to the display substrate accommodating tray and thus being inserted into the plurality of openings respectively.

In one embodiment of the invention, the plurality of first supporting members are inserted into the plurality of openings vertically.

According to still another aspect of the invention, a method for removing a display substrate from a display substrate accommodating tray is provided. The display substrate accommodating tray includes a bottom section for mounting a display substrate thereon in a substantially horizontal fashion, with a plurality of openings being formed in the bottom section, and a frame for surrounding at least a part of the display substrate when the display substrate is mounted on the bottom section. The method comprising the steps of when the display substrate is mounted on the bottom section, moving a plurality of supporting members upward relative to the display substrate accommodating tray, thereby inserting the plurality of supporting members into the plurality of openings respectively; and raising the mounted display substrate above the bottom section by the plurality of supporting members.

Thus, the invention described herein makes possible the advantages of providing a display substrate accommodating tray for accommodating a great number of display substrates in a limited space and allowing the display substrates to be transported and stored with high

efficiency without contacting each other, and an apparatus and a method for easily removing the display substrates accommodated in the display substrate accommodating tray.

These and other advantages of the present invention will become apparent to those skilled in the art upon reading and understanding the following detailed description with reference to the accompanying figures.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a plan view of a display substrate accommodating tray according to an example of the present invention;

Figure 2 is a perspective view of the display substrate accommodating tray shown in Figure 1;

Figure 3 is a partial cross-sectional view of the display substrate accommodating tray shown in Figure 1;

Figure 4 is a partial cross-sectional view of two display substrate accommodating trays, each of which is shown in Figure 1, stacked vertically;

Figure 5 is a cross-sectional view of a plurality of display substrate accommodating trays, each of which is shown in Figure 1, stacked vertically for transportation and storage;

Figure 6 is a schematic view of a carrying apparatus and a display substrate removing apparatus according to an example of the present invention;

Figure 7 is a schematic view of the carrying apparatus and the display substrate removing apparatus shown in Figure 6 with a display substrate adsorption hand;

Figure 8 is a schematic view of the carrying apparatus and the display substrate removing apparatus shown in Figure 6, illustrating another operation thereof; and

Figure 9 is a schematic view of a display substrate removing apparatus according to another example of the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Hereinafter, the present invention will be described by way of illustrative examples with reference to the accompanying drawings.

Figure **1** is a plan view illustrating a display substrate accommodating tray **10** according to an example of the present invention. Figure **2** is a perspective view of the display substrate accommodating tray **10**, and Figure **3** is a partial cross-sectional view of the display substrate accommodating tray **10** taken along line **A-A** in Figure **1**. The display substrate accommodating tray **10** is useful for accommodating a glass substrate used for, for example, a liquid crystal display panel; specifically, a glass substrate having a side length of 1.3 m or greater and a thickness of 0.7 mm or less, for transportation or storage.

The display substrate accommodating tray **10** according to the present invention is molded to be a thin rectangular parallelepiped. The display substrate accommodating tray **10** includes a rectangular bottom section **11** for mounting thereon a glass substrate **20** as

a display substrate in a substantially horizontal fashion, and a frame **12** for surrounding the entire periphery of the glass substrate **20** when the glass substrate **20** is mounted on the bottom section **11**. The frame **12** is provided along the entire periphery of the bottom section **11**, and projects to a level higher than the level of a top surface of the bottom section **11**. The bottom section **11** and the frame **12** are integrally molded from a foam polyethylene resin, which is a synthetic resin foam material, or the like. The frame **12** may be provided along the periphery of the bottom section **11** such that the frame **12** surrounds at least a part of the glass substrate **20**.

The bottom section **11** has a rectangular shape which is slightly larger than the glass substrate **20**, and has a thickness of, for example, about 15 mm. The glass substrate **20** is mounted on the top surface of the bottom section **11**.

Square openings **11a** are formed in the vicinity of the corners of the bottom section **11** and at intermediate positions between the corners along the four sides of the bottom section **11**. A square opening **11a** is also formed at the center of the bottom section **11**. Thus, the bottom

section **11** has nine openings **11a** in a 3 × 3 matrix. Support pins **43** (Figure **6**) can be inserted into the openings **11a** as supporting members. The support pins **43** raise the glass substrate **20** from the bottom section **11** for removing the glass substrate **20** from the display substrate accommodating tray **10**.

The frame **12** is provided along the entire periphery of the bottom section **11** as described above, and has a width of about 30 mm. The frame **12** projects to a level higher than the level of the top surface of the bottom section **11** by about 5 mm or greater. The frame **12** surrounds the entire periphery of the glass substrate **20** mounted on the bottom section **11** at an appropriate distance from the edge of the glass substrate **20**.

An engaging section **13** is provided along the entire periphery of the frame **12**. More specifically, the engaging section **13** is provided such that a step is formed between a bottom surface of the engaging section **13** and a bottom surface of the frame **12**, and projects to a level higher than a top surface of the frame **12**. The engaging section **13** has a width of, for example, about 30 mm and horizontally projects outward from the frame **12**. The engaging section

13 has a rectangular cross-section, and is engageable with a chuck nail (not shown in Figure 1) for chucking. The chuck nail acts as a transfer member for transferring the display substrate accommodating tray 10 to a prescribed position. The bottom section 11, the frame 12, and the engaging section 13 may be integrally molded from a foam polyethylene resin or the like.

A top surface of the engaging section 13 extends horizontally outside and above the top surface of the frame 12. The frame 12 has a positioning step 14 (positioning portion; Figure 3), which is provided between the top surface of the engaging section 13 and the top surface of the frame 12. The positioning step 14 is vertical to the top surface of the frame 12. The positioning step 14 is provided along the periphery of the frame 12, and acts to determine the positional relationship between the display substrate accommodating tray 10 and another display substrate accommodating tray 10 which is to be stacked thereon.

In the display substrate accommodating tray 10 having the above-described structure, the glass substrate 20 (for example, a glass substrate for a liquid crystal

panel having a thickness of 0.7 mm or less) is accommodated on the top surface of the bottom section **11**. A surface of the glass substrate **20** which does not have electrodes or the like is in contact with the top surface of the bottom section **11**. As described above, the bottom section **11** is slightly larger than the glass substrate **20**, and thus the glass substrate **20** is mounted on the bottom section **11** at an appropriate distance from the edge of the frame **12**.

As shown in Figure **4**, a plurality of display substrate accommodating trays **10** (only two are shown in Figure **4** for the sake of simplicity) each accommodating a glass substrate **20** can be stacked vertically and transported in this state. A bottom edge of the frame **12** of an upper display substrate accommodating tray (indicated by reference numeral **10a** for the sake of clarity) is engaged with the positioning step **14** of a lower display substrate accommodating tray (indicated by reference numeral **10b** for the sake of clarity). Therefore, the display substrate accommodating trays **10a** and **10b** stacked vertically do not slip in a horizontal direction with respect to each other.

For example, about 20 display substrate accommodating trays **10** each accommodating a glass substrate **20** can be stacked vertically and transported. Each display substrate accommodating tray **10** is thin as described in detail below, and thus significantly improves the space efficiency. As a result, a great number of glass substrates **20** can be transported and stored with high efficiency.

For actual transportation of a prescribed number of display substrate accommodating trays **10**, a lid **61** and a bottom plate **62** shown in Figure **5** are engaged with an uppermost display substrate accommodating tray **10** and a lowermost display substrate accommodating tray **10**, respectively. The plurality of vertically stacked display substrate accommodating trays **10** are transported and stored with the lid **61** and the bottom plate **62** as one unit. The lid **61** is engaged with the positioning step **14** of the uppermost display substrate accommodating tray **10** and thus seals the uppermost display substrate accommodating tray **10**. Therefore, the glass substrate **20** accommodated in the uppermost display substrate accommodating tray **10** is protected against dust or the like.

The bottom plate **62** is engaged with the bottom section **11** and the frame **12** (Figure **3**) of the lowermost display substrate accommodating tray **10**. Therefore, the glass substrate **20** accommodated in the lowermost display substrate accommodating tray **10** is protected against dust or the like.

The glass substrates **20** accommodated in the vertically stacked display substrate accommodating trays **10** can be transported by a truck or the like while being sealed by the lid **61**, the bottom plate **62**, the frame **12** and the engaging section **13**. Therefore, a container or the like for accommodating the display substrate accommodating trays **10** is not necessary.

In such a stacked structure, the weight of an upper display substrate accommodating tray **10** is supported by the frame **12** of the display substrate accommodating tray **10** below. Especially when a great number of display substrate accommodating trays **10** are stacked, the width of the frame **12** is increased in order that the lowermost display substrate accommodating tray **10** (Figure **5**) is not broken. For example, when ten display substrate

accommodating trays **10** each accommodating a glass substrate **20** are stacked vertically, the width of the frame **12** is preferably about 100 mm.

The frame **12** may be reinforced by a reinforcing material such as metal or the like.

Instead of using the lid **61** and the bottom plate **62**, a prescribed number of display substrate accommodating trays **10** may merely be stacked and put into a container, for example, a metal box. In this case, a plurality of such metal boxes can be stacked vertically, which further improves the space efficiency during transportation.

A bottom surface of the frame **12** of the uppermost display substrate accommodating tray **10** is engaged with the positioning step **14** of the display substrate accommodating tray **10** below. Therefore, there is an appropriate space between the engaging section **13** of the uppermost display substrate accommodating tray **10** and the engaging section **13** of the display substrate accommodating tray **10** below. This allows a chuck nail to be inserted between these engaging sections **13**. The chuck nail is engaged with the engaging section **13** of the uppermost

display substrate accommodating tray **10**, so that only the uppermost display substrate accommodating tray **10** can be separated from the other display substrate accommodating trays **10** in the stack.

With reference to Figures **6** through **8**, a method for removing the glass substrates **20** from the plurality of vertically stacked display substrate accommodating trays **10** according to the present invention will be described. Figure **6** shows a carrying apparatus **30** and a display substrate removing apparatus **40** according to an example of the present invention. The carrying apparatus **30** catches and carries each display substrate accommodating tray **10**. The display substrate removing apparatus **40** removes a glass substrate **20** from each display substrate accommodating tray **10**.

The carrying apparatus **30** is, for example, a crane type carrying apparatus which is movable in an upper space of a plant. The carrying apparatus **30** includes a plurality of chucks **31**. (Figure **6** shows only one chuck **31** for simplicity.) Each chuck **31** includes a pair of chuck nails **31a**. Each chuck nail **31a** is engageable with the engaging section **13** of the display substrate accommodating tray

10.

When a plurality of display substrate accommodating trays 10 are carried to a plant, the chuck nails 31a of the carrying apparatus 30 are inserted into the gap between the engaging section 13 of an uppermost display substrate accommodating tray 10 and the engaging section 13 of the next uppermost display substrate accommodating tray 10, and are engaged with the engaging section 13 of the uppermost display substrate accommodating tray 10. Then, the chucks 31 are moved upward, and thus the uppermost display substrate accommodating tray 10 is separated from the other display substrate accommodating trays 10 in the stack. The separated display substrate accommodating tray 10 is carried to the display substrate removing apparatus 40 by the chucks 31.

The display substrate removing apparatus 40 includes a fixed table 41 and an elevatable table 42 provided so as to be slidable up and down with respect to the fixed table 41. The fixed table 41 has nine support pins 43, which are arranged in a 3 × 3 matrix in correspondence with the nine openings 11a (Figure 1) of the bottom section

11 of the display substrate accommodating tray 10. The support pins 43 extend vertically to the elevatable table 42. The elevatable table 42 is supported above the fixed table 41 by a plurality of coil springs 44 so as to slide up and down in a horizontal fashion. The support pins 43 can slidably pass through the elevatable table 42. The elevatable table 42 acts as a supporting member for supporting the display substrate accommodating tray 10.

The display substrate accommodating tray 10 is placed on the elevatable table 42 by the chucks 31. The display substrate accommodating tray 10 is positioned with respect to the elevatable table 42 such that the support pins 43 correspond to the openings 11a, respectively. When the chuck nails 31a are disengaged from the engaging section 13, the elevatable table 42 slides down by the force of the weight of the display substrate accommodating tray 10 against the coil springs 44. Thus, a top portion of each support pin 43 passes through the elevatable table 42 and projects upward from the elevatable table 42.

Thus, as shown in Figure 7, the support pins 43 are vertically inserted into the corresponding openings 11a and contact the glass substrate 20 mounted on the bottom

section **11**. The glass substrate **20** is raised from the display substrate accommodating tray **10** by the support pins **43**. The glass substrate **20** is supported in a horizontal fashion by the support pins **43** above the display substrate accommodating tray **10**. Thus, the glass substrate **20** is removed upwardly from the inside of the display substrate accommodating tray **10**, and an appropriate space is provided between the display substrate accommodating tray **10** and the glass substrate **20**.

Then, the glass substrate **20** is transferred to a prescribed position by a display substrate adsorption hand (for example, a glass substrate adsorption hand) **50**. The display substrate adsorption hand **50**, which is commonly used for transferring glass substrates by adsorption, includes a pair of adsorption pads **51** which are parallel to each other. Each adsorption pad **51** is a flat plate having a thickness of about 20 mm or greater, and can vacuum-adsorb a bottom surface of the glass substrate **20**. The adsorption pads **51** are inserted between the display substrate accommodating tray **10** and the raised glass substrate **20**. The adsorption pads **51** slide upward, so that the glass substrate **20** is placed on, and

vacuum-adsorbed by, the adsorption pads **51**. Then, the glass substrate **20** and the adsorption pads **51** are raised, and the adsorption pads **51** slide horizontally so as to transfer the glass substrate **20** to a prescribed position.

When the glass substrate **20** is taken to the prescribed position by the display substrate adsorption hand **50**, the chuck nails **31a** are again engaged with the engaging section **13** of the display substrate accommodating tray **10** on the elevatable table **42** as shown in Figure **8**. The chucks **31** are moved upward, so that the display substrate accommodating tray **10** is removed from the elevatable table **42**. The display substrate accommodating trays **10** from which the glass substrates **20** have been removed are stacked vertically at another prescribed position.

As described above, the display substrate accommodating tray **10** accommodates only one glass substrate **20**. A plurality of such display substrate accommodating trays **10**, which are stacked vertically, are transported and stored. Therefore, the glass substrates **20** do not contact each other. Since no space is necessary for inserting the adsorption pads **51** in the display substrate accommodating tray **10**, the glass substrate **20**

can be directly placed on the bottom section **11**. As a result, the glass substrate **20** is not warped and a display substrate accommodating tray **10** can be significantly reduced in thickness.

In order to transfer a glass substrate having a side length of 1.3 m or greater, the adsorption pad **51** needs to have a thickness of 20 mm or greater.

The substrate tray cassette disclosed by Japanese Laid-Open Publication No. 10-287382 has the adsorption pads inserted thereinto. This requires a space of at least 20 mm for inserting the adsorption pads between the bottom section of a substrate tray cassette and a glass substrate. In addition, in order to prevent a glass substrate having a thickness of, for example, 1 mm from contacting a substrate tray cassette to be stacked thereon, the distance between the top surface of the glass substrate and the top surface of the frame is set to be 5 mm. The thickness of the bottom section of the substrate tray cassette is set to be 15 mm. When a plurality of substrate tray cassettes are stacked, the height of each substrate tray cassette, except for the uppermost tray cassette, is at least 41 mm (20 + 1 + 5 + 15 = 41).

By contrast, the display substrate accommodating tray **10** according to the present invention has a glass substrate **20** having a thickness of, for example, 1 mm directly placed on the bottom section **11**. The distance between the top surface of the glass substrate **20** and the top surface of the frame **12** is also set to be 5 mm, and the thickness of the bottom section **11** is also set to be 15 mm. When a plurality of display substrate accommodating trays **10** are stacked, the height of each display substrate accommodating tray **10**, except for the uppermost display substrate accommodating tray **10**, is 21 mm (1 + 5 + 15 = 21). Thus, the display substrate accommodating tray **10** according to the present invention can be significantly thinner than the conventional substrate tray cassette.

The display substrate accommodating tray **10** according to the present invention, which is significantly thinner, can be significantly more lightweight (for example, about 5 kg). Where one glass substrate **20** weighs 5 kg, the display substrate accommodating tray **10** accommodating the glass substrate **20** weighs about 10 kg. Such a display substrate accommodating tray **10**, even

accommodating a glass substrate **20**, can be easily transported by one worker.

The display substrate accommodating tray **10** includes the engaging section **13** to be engaged with the chuck nails. Owing to this structure, the uppermost display substrate accommodating tray **10** of the stack can be easily separated from the other display substrate accommodating trays **10** of the stack.

Owing to the support pins **43** for supporting the glass substrate **20** being inserted into the openings **11a** of the bottom section **11**, the glass substrate **20** can be easily removed out of the display substrate accommodating tray **10**.

The openings **11a** can have any shape with no specific limitation as long as the support pins **43** can be inserted thereinto. A greater number of openings **11a** may be formed in the bottom section **11**, or the bottom section **11** may be formed to have a lattice structure, as long as the bottom section **11** is sufficiently strong to support the glass substrate **20**.

Since each display substrate accommodating tray **10** is lightweight, as many as 20 display substrate accommodating trays **10** can be stacked vertically even when each glass substrate **20** accommodated is as heavy as 5 kg.

In the above example, the positioning step **14** is formed along the entire periphery of the frame **12**. The positioning step **14** does not need to be formed along the entire periphery of the frame **12** as long as the vertically stacked display substrate accommodating trays **10** do not slip in a horizontal direction. For example, the positioning step **14** may be formed at four positions in the vicinity of the corners of the display substrate accommodating tray **10**. Alternatively, the positioning step **14** may be formed intermittently at appropriate positions around the frame **12**.

The engaging section **13** projects outwardly in a horizontal direction from the upper portion of the side surfaces of the frame **12**. The engaging section **13** is not limited to such a shape. For example, the engaging section **13** may be formed by tapering the bottom surface of the frame **12** such that the bottom surface is inclined upward toward the periphery. In this case, a recess or inclining

portion may be formed in the top surface of the frame **12** as a positioning portion. The engaging section **13** may be, for example, a cut-out section or recessed section made in the side surfaces of the frame **12**. The engaging section **13** does not need to be provided along the entire periphery of the frame **12**; instead, about 2 or 3 engaging sections may be provided in each side surface.

The carrying apparatus **30** for chucking and carrying the display substrate accommodating tray **10** is not limited to a crane type apparatus movable in the upper space of a plant, but may be a combination of a pair of support rods extending vertically so as to be movable along rails or the like provided on the floor of the plant, and chuck nails provided on the support rods so as to be movable up and down.

In the display substrate removing apparatus **40** for removing a glass substrate **20** from a display substrate accommodating tray **10**, the elevatable table **42** is horizontally supported by the coil springs **44**. The elevatable table **42** may be moved up and down by ball screws, air cylinders or the like. The support pins **43** may be movable instead of the elevatable table **42**. The display

substrate accommodating tray **10** may be moved by application of a driving force. Instead of the elevatable table **42**, the chucks **31** may act as supporting members for supporting a display substrate accommodating tray **10** while removing a glass substrate **20** from the display substrate accommodating tray **10**. The carrying apparatus **30** may be included in the display substrate removing apparatus **40**. The supporting member for supporting the display substrate accommodating tray **10** is not limited to the elevatable table **42**, but may be any element which can change the relative positions of the display substrate accommodating tray **10** and the support pins **43**.

In the above example, the support pins **43** are used for removing a glass substrate **20** from a display substrate accommodating tray **10**. Instead of the support pins **43**, supporting members having a rod structure, i.e., having a larger top area, may be used.

Figure **9** shows a display substrate removing apparatus **40a** as a modification of the display substrate removing apparatus **40** shown in Figure **6**. The display substrate removing apparatus **40a** includes a plurality of rod-like supporting members **45** instead of the plurality

of support pins **43**. A roller **46** rotatable by a motor or the like is provided at a top end of each supporting member **45**. The display substrate removing apparatus **40a** is identical to the display substrate removing apparatus **40** except for these points. The glass substrate **20** which is raised in contact with the rollers **46** is transferred in a horizontal direction by the rotation of the rollers **46**. The glass substrate **20** may be horizontally transferred to a roller transfer apparatus **47** without being raised by the display substrate adsorption hand **50** or the like.

In the above example, an accommodating tray for accommodating a glass substrate for a liquid crystal display panel is described. The present invention is not limited to this, and is applicable to an accommodating tray for accommodating a glass substrate for other types of display panels. The present invention is also applicable to an accommodating tray for accommodating a synthetic resin substrate.

According to the present invention, a plurality of display substrate accommodating trays can be stacked vertically with each display substrate accommodating tray accommodating one display substrate. Therefore, the

display substrates accommodated in the display substrate accommodating trays do not contact each other.

Since the bottom section of the display substrate accommodating tray has a plurality of openings, the display substrate can be removed out of the display substrate accommodating tray by inserting the supporting pins into the openings. Owing to such a structure, the display substrate accommodating tray does not need to have any special space for inserting the adsorption pads. This reduces the thickness of the display substrate accommodating tray and increases the space efficiency for transportation and storage.

When stacked vertically, a great number of display substrate accommodating trays can be transported and stored as one unit. It is also possible to handle each display substrate accommodating tray individually by one worker.

The present invention also provides an apparatus and a method for easily removing a display substrate from such a display substrate accommodating tray.

Various other modifications will be apparent to and can be readily made by those skilled in the art without departing from the scope and spirit of this invention. Accordingly, it is not intended that the scope of the claims appended hereto be limited to the description as set forth herein, but rather that the claims be broadly construed.